

Date: Tuesday, 15/07/2008 9:12:04 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 40462			Part Number	: D32203	
Estimate Number	: 10296			Drawing Number	: D3220 REV A1	
P.O. Number	:			Project Number	: N/A	
This Issue	: 15/07/2008		S.O. No. :	Drawing Revision	: A1	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	SMALL /MED FAB	Due Date	21/07/2008
Previous Run	: 40461D			Qty:	10	Um: Each
Written By	:					
Checked & Approved By	: <u>JUL 08 /S-08</u>					
Comment	: Est Rev: A New Issue 05-11-06 JLM					
	Est: B 06.11.15 waterjet EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S050	2024-T3 .050 sheet	
		Comment: Qty.: 0.6233 sf(s)/Unit Total : 6.2328 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050)	(12)
		Identify for D3220-3 Batch: <u>107711</u>	
2.0	WATER JET	FLOW WATER JET	
		A1 A1 18 8-7-17	
		Comment: FLOW WATER JET	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		18 8-7-17	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>S08/07/17-12</u>	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		<u>20/07/08/07/17-12</u>	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:12:04 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 40462

Part Number: D32203

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-07-17

7.0 PACKAGING 1

PACKAGING RESOURCE #1



12x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 234

8/7/17

SP

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/18 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



20/07/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40467
Description: Doubler	Part Number:	D3220-3
Inspection Dwg: D3220	Rev: A1	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>B</u>	Audited by: <u>  </u>	Prototype Approval: N/A
Date: 8-7-17	Date: 08/07/17	Date: N/A

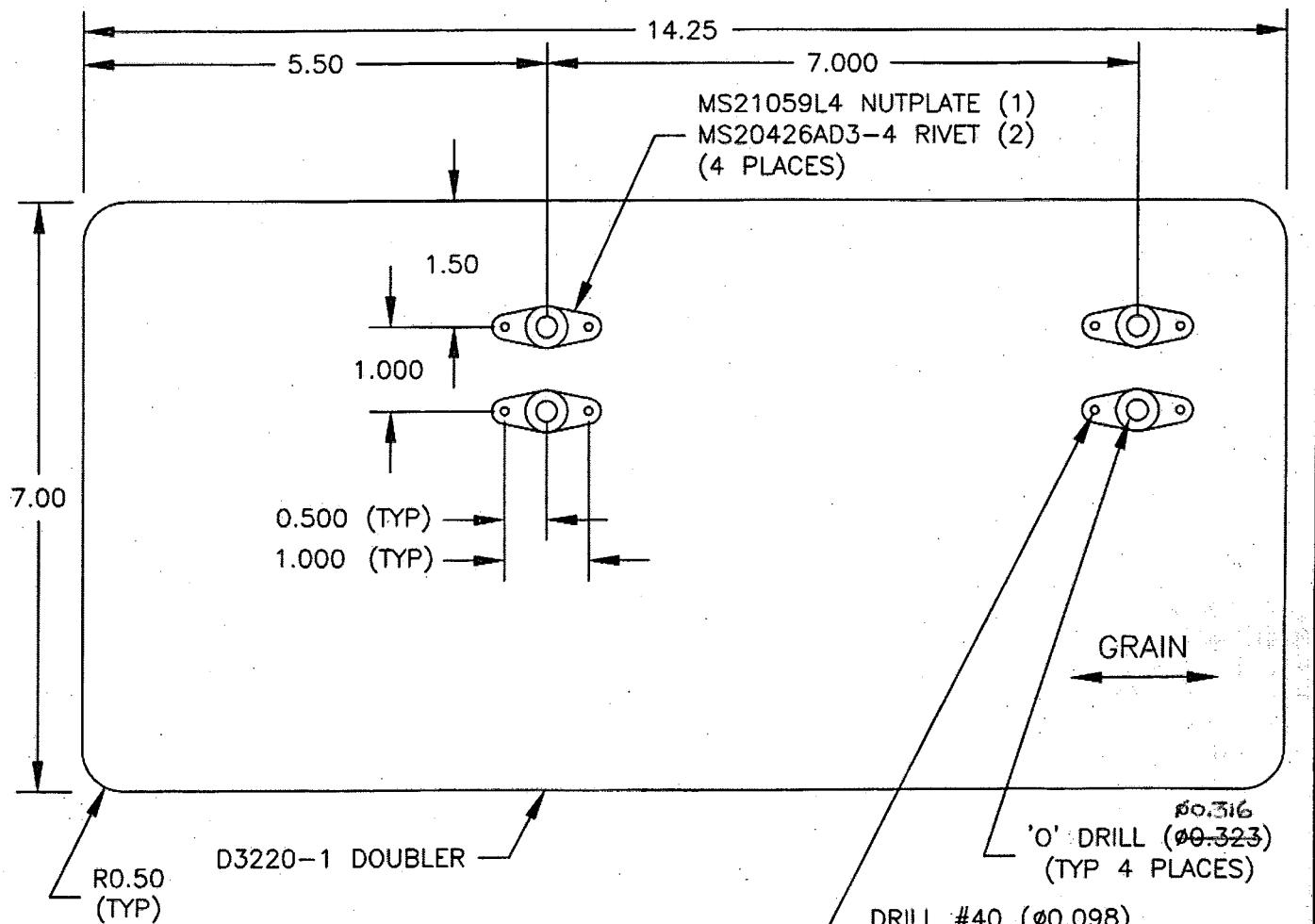
Rev	Date	Change	Revised by	Approved
A	04.02.27	New Issue	P/O D412-698-013	KJ/RF <i>[Signature]</i> <i>[Signature]</i>



DESIGN <i>HP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>HP</i>	APPROVED <i>HP</i>	DRAWING NO. D3220	REV. A SHEET 1 OF 2	
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2	
A	03.10.16	NEW ISSUE		
A1	<i>CP</i> <i>HP</i> 03.11.13	CORRECTED DIM		

RELEASED  
03.11.14

03.11.14



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLE)

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

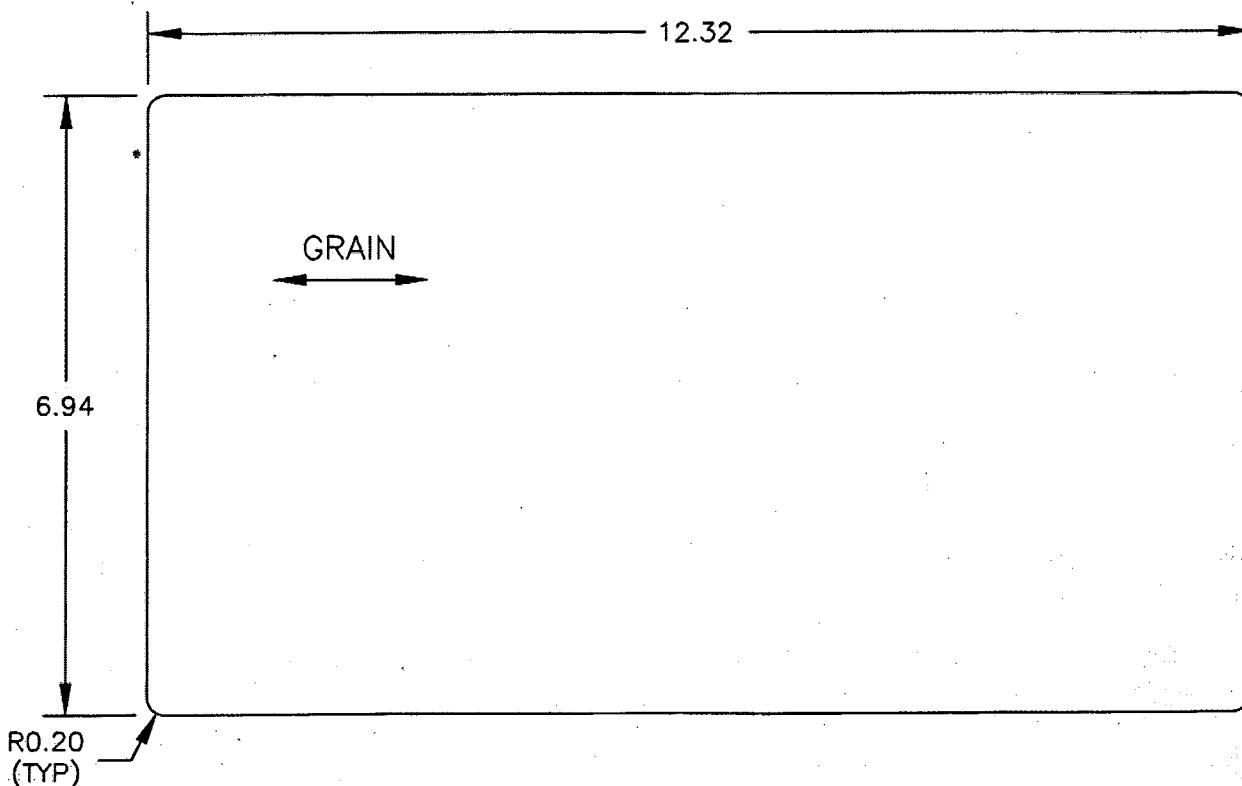
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WITHOUT NOTICE  
WORK ORDER  
NO. 40462

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3220	SHEET 2 OF 2

DATE  
03.10.16TITLE  
DOUBLERSCALE  
1:2**RELEASED**

03.11.14

**D3220-3 DOUBLER**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 10462

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